

Date: Tuesday, 04/07/2006 12:39:11 PM  
User: Linda Lacelle

# Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : WEARSHOE
Job Number : 27739	
Estimate Number : 10314	
P.O. Number : <i>N/A</i>	Part Number : D265613
This Issue : 04/07/2006 S.O. No. : <i>N/A</i>	Drawing Number : D2656 REV D
Prsht Rev. : NC	Project Number : N/A
First Issue : 28/06/2006 Type : PURCHASED PARTS	Drawing Revision : D
Previous Run : 27074	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 30/07/2006 Qty: 50 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: F 02.10.25 Re-format KJ/RF	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M1010S20GA	1010/1025/A21/6aA SHEET
-----	------------	-------------------------



*M100473*



Comment: Qty.: 0.5110 sf(s)/Unit Total: 25.5500 sf(s)  
1010/1025/A21/6aA SHEET

*ml 06 07 13*

2.0	WATER JET	FLOW WATER JET
-----	-----------	----------------



Comment: FLOW WATER JET

*ml 08 09 11*

*(50)*

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*ml 08 09 11*

*(50)*

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-13T1

*06 09 12*  
*count (51)*

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr if necessary.

*SAN 06 09 17*

*(51)*

6.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326  
2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

*SB 06 09 21 51*

Date: Tuesday, 04/07/2006 12:39:11 PM  
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27739

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

*Job 08-26 (51)*

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

*06-09-27*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

*FC 06 10 02 (51)*

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: *FP21*

*FC 06 10 02 (51)*

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*06/10/03*

Job Completion



*u 06/10/03*

*[Signature]*

Date: Wednesday, 6/28/2006 4:17:29 PM  
 User: Kim Johnston

## Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARSHOE
Job Number	: 27739		
Estimate Number	: 10314		
P.O. Number	:	Part Number	: D265613
This Issue	: 6/28/2006 S.O. No. :	Drawing Number	: D2656 REV D
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/1 Type : PURCHASED PARTS	Drawing Revision	: D
Previous Run	: 27074	Material	:
Written By	: <u>06 06 29</u>	Due Date	: 7/30/2006 Qty: 50 Um: Each
Checked & Approved By	: <u>06 06 29</u>		
Comment	: Est: 02.10.25 Re-format KJ/RF		

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O:

1-Email or ship DXF file to vendor

2-Laser Cut per Dwg D2656 flat pattern D2656-13

3-Material release note required

2.0 D265613F



Waten Jet. Wearplate

Dry Rev: D Png Rev: D

Comment: Qty.: 1.0000 Each(s)/Unit Total: 50.0000 Each(s)

WEAR PLATE

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Receive &amp; Inspect For Transit Damage

Ensure material release note is attached

4.0	QCC	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions per template D2656-13T1

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL &amp; MEDIUM FAB RESOURCE 1

Deburr if necessary.

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Date: Wednesday, 6/28/2006 4:17:29 PM  
User: Kim Johnston

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARSHOE

Job Number: 27739

Part Number: D265613

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form on Brake as per Dwg D2656 using Jigs DT8261 and DT8326

2-Form joggle as per Dwg D2656 using Jig DT8158 Identify as D2656-13

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: \_\_\_\_\_

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			

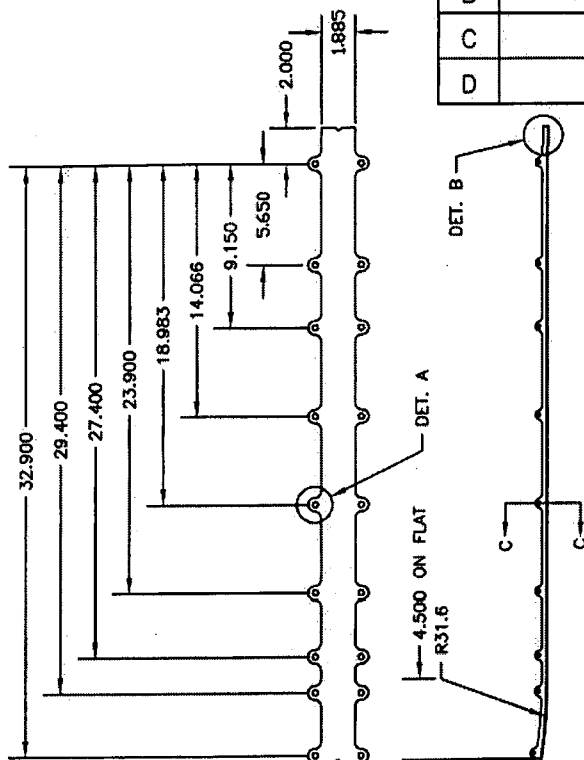
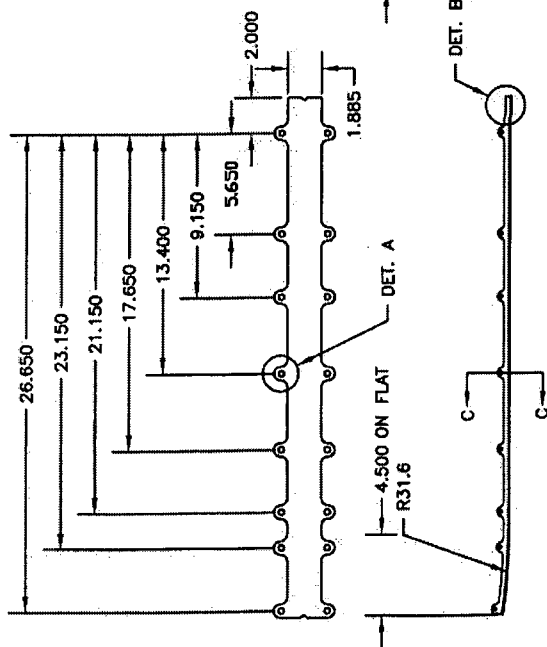
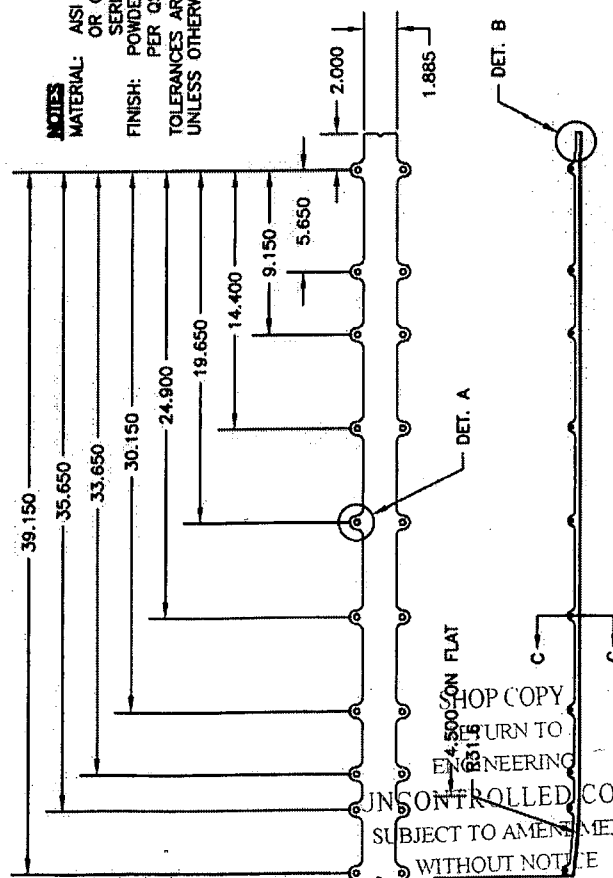
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

NOTE: Date & initial all entries

QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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				REV. D SHEET 1 OF 4
DATE	05.08.17	TITLE	WEARSHOE	SCALE 1:10
A	97:03:25	NEW ISSUE		
B	97:06:02	CHANGED TABS		
C	97:06:26	R31.6 WAS R19.5		
D	05.08.17	ENLARGE ALL HOLES TO IMPROVE FIT		

**D2656-13****D2656-11****D2656-15**

**NOTES**  
MATERIAL: ANSI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANITEX (4.3.5.6)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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05.09.06

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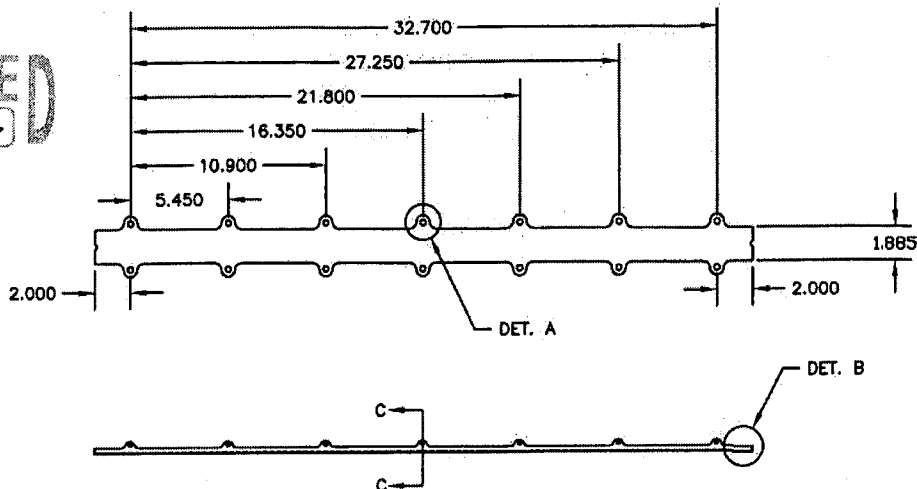
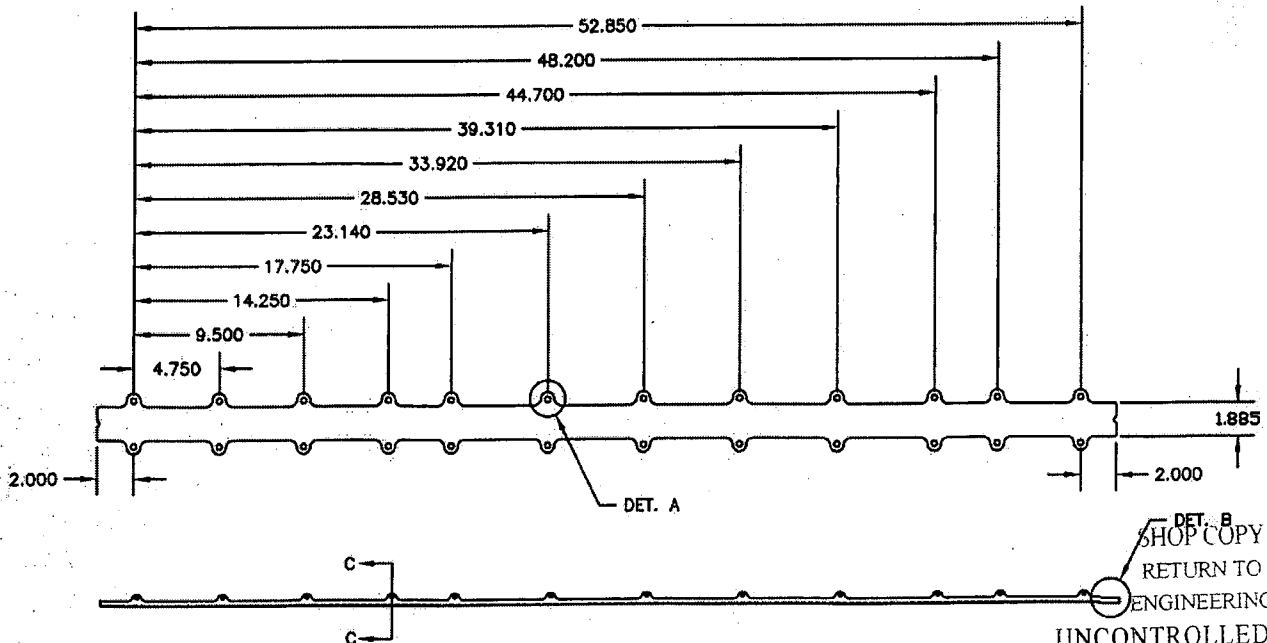
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DATE <b>05.08.17</b>		TITLE <b>WEARSHOE</b>	SCALE <b>1:10</b>

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05.07.06 *[Signature]***D2656-21****D2656-23****NOTES**

MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W  
SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
UNLESS OTHERWISE NOTED

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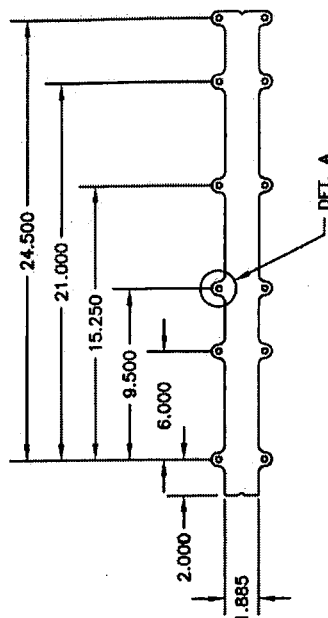
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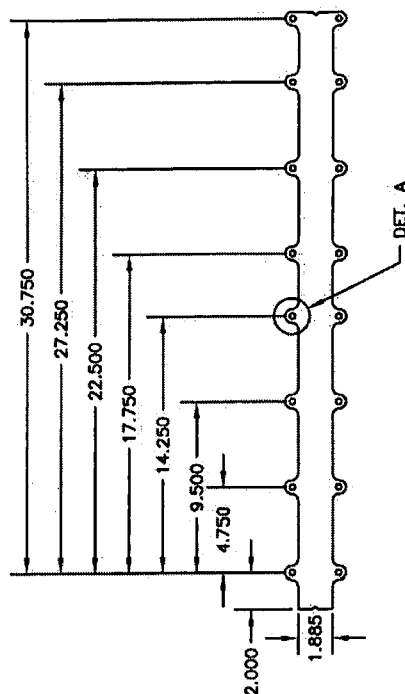


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DATE 05.08.17		TITLE WEARSHOE	SCALE 1:10

D2656-33

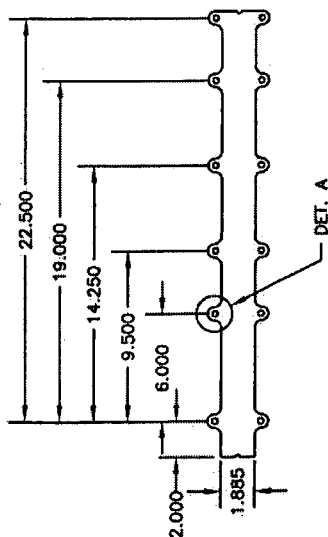


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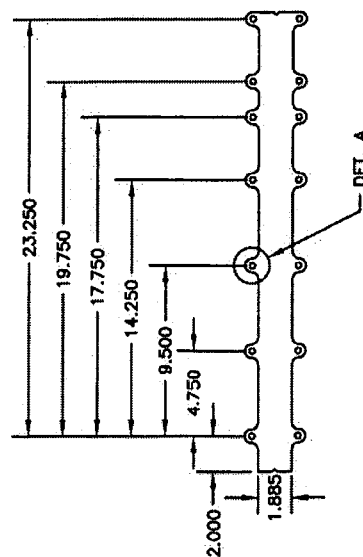


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D2656-35



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SERIES STEEL, 20 GAUGE (0.040 THICK)  
FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3  
TOLERANCES ARE PER DART QSI 018  
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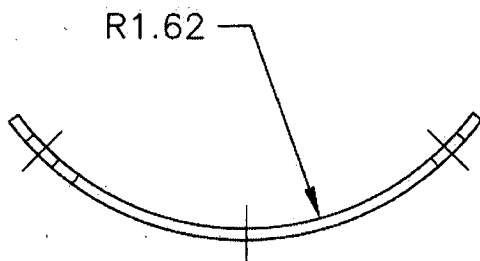
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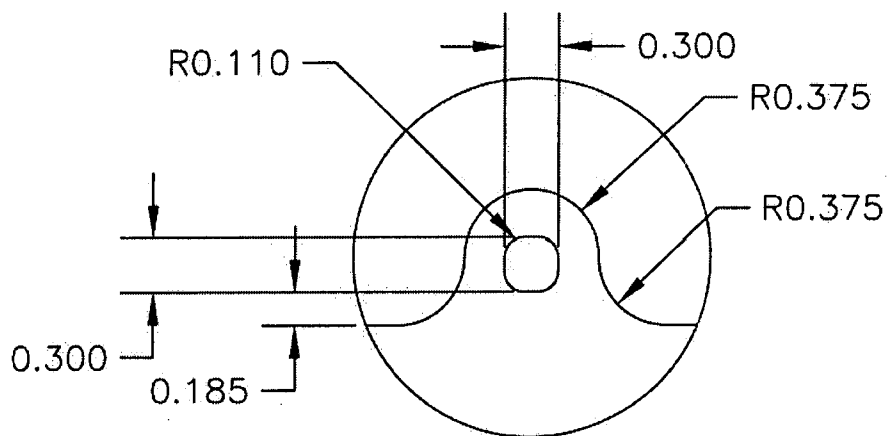
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DATE 05.08.17	TITLE WEARSHOE		SCALE 1:10

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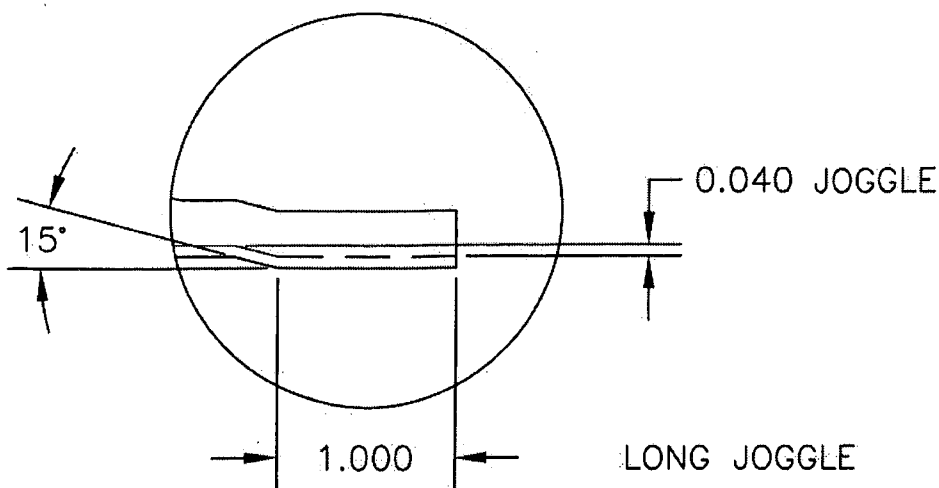


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### DETAIL A



### DETAIL B



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